

Date: Thursday, 10/11/2007 2:55:21 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VALVE SEAL
Job Number : 35142	
Estimate Number : 12207	
P.O. Number : N/A	Part Number : D34707
This Issue : 10/11/2007 S.O. No. : N/A	Drawing Number : D3470 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34412	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 10/30/2007 Qty: <u>16</u> Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: A New Issue 06-04.20 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MSIL60S063	High Temp Silicon Sheet 0.063"
-----	------------	--------------------------------



Comment: Qty.: 0.0648 sf(s)/Unit Total : 0.5183 sf(s)  
 Material .063" Thick High Temp Silicone sheet  
 (M-SIL60S.063)  
 Batch: M105100 IB 07-10-17

+10

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 Cut as per Dwg D  
 Dwg Rev: A  
 Prog Rev: A

IB 07-10-17

(17)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

counter  
5 210/18 (17)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: 97

6/7/10/18 (17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 07/18/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:55:21 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VALVE SEAL

Job Number: 35142

Part Number: D34707

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(17)

Comment: FINAL INSPECTION/W/O RELEASE

Done 10/18

Job Completion



u 07-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

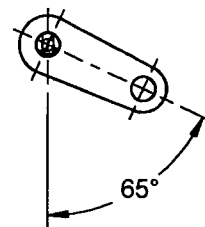
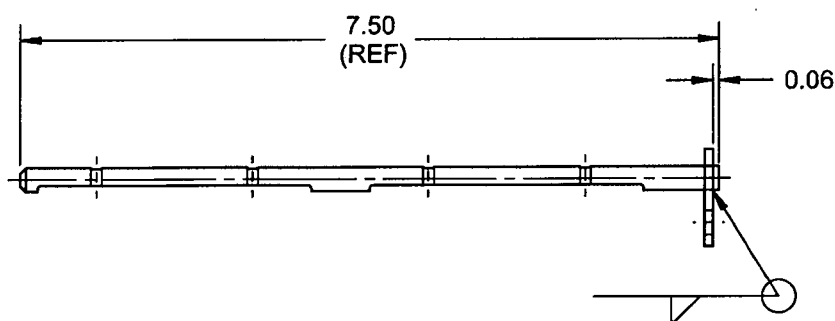
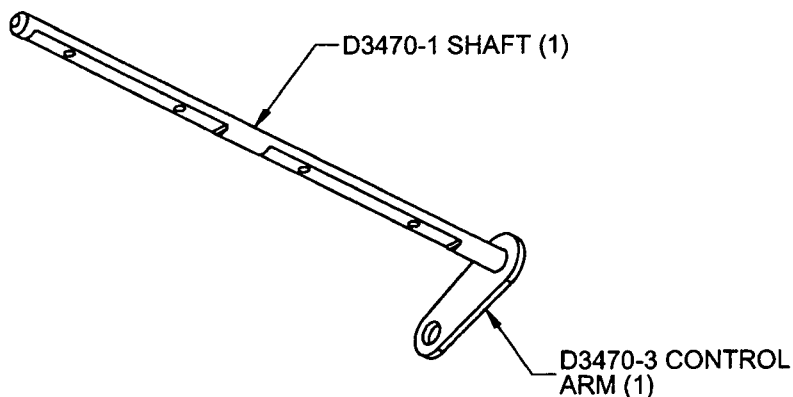
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3470</b>	REV. A SHEET 1 OF 4
DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:2
A	05.12.14	NEW ISSUE	



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### D3470-041 SHUT-OFF VALVE SHAFT

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *35142*

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

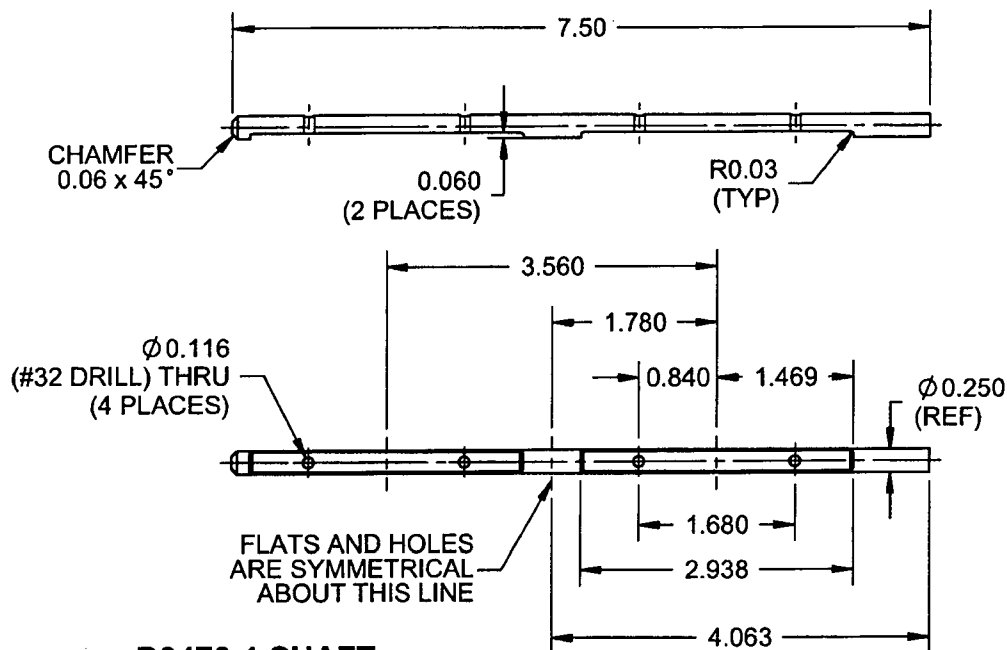
QTY -041	P/N	DESCRIPTION
X	D3470-041	SHUT-OFF VALVE SHAFT
1	D3470-1	SHAFT
1	D3470-3	CONTROL ARM

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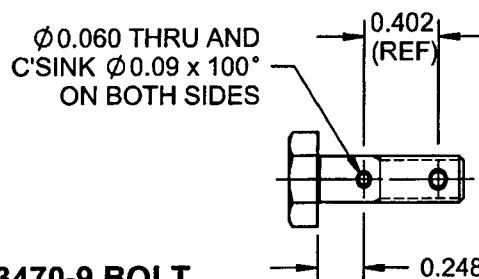
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3470</b>	REV. A SHEET 2 OF 4
DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:2

**D3470-1 SHAFT**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR  
(REF. DART SPEC. M303R0.250)

**D3470-9 BOLT**

SCALE 1:1

- 1) MAKE FROM AN4-6 BOLT

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

06-04-03  
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NO. 35142

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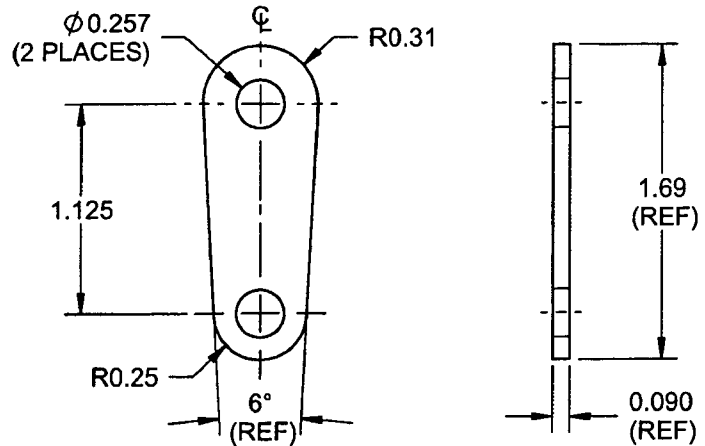
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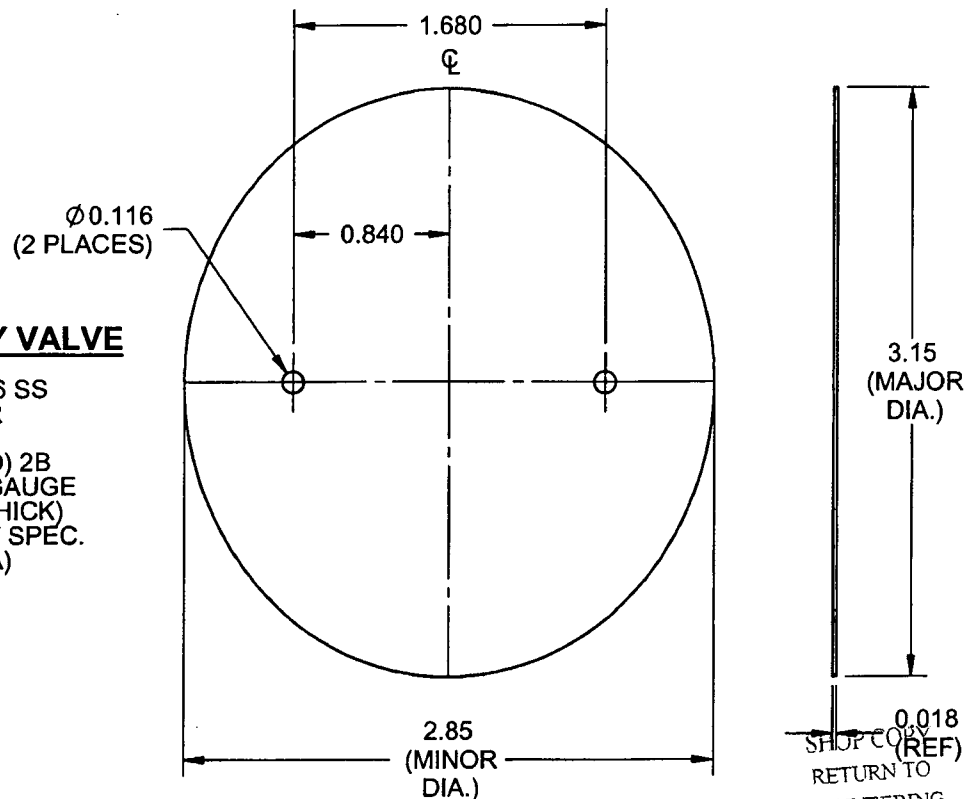
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DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:1

**D3470-3 CONTROL ARM**

- 1) MATERIAL: AISI 304/316 SS SHEET PER  
MIL-S-5019 (ANNEALED) 2B  
FINISH 13 GAUGE SS  
(0.090 THICK)  
(REF. DART SPEC. M304S13GA)

**D3470-5 BUTTERFLY VALVE**

- 1) MATERIAL: AISI 304/316 SS  
SHEET PER  
MIL-S-5019  
(ANNEALED) 2B  
FINISH 26 GAUGE  
SS (0.018 THICK)  
(REF. DART SPEC.  
M304S26GA)

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. **35142**

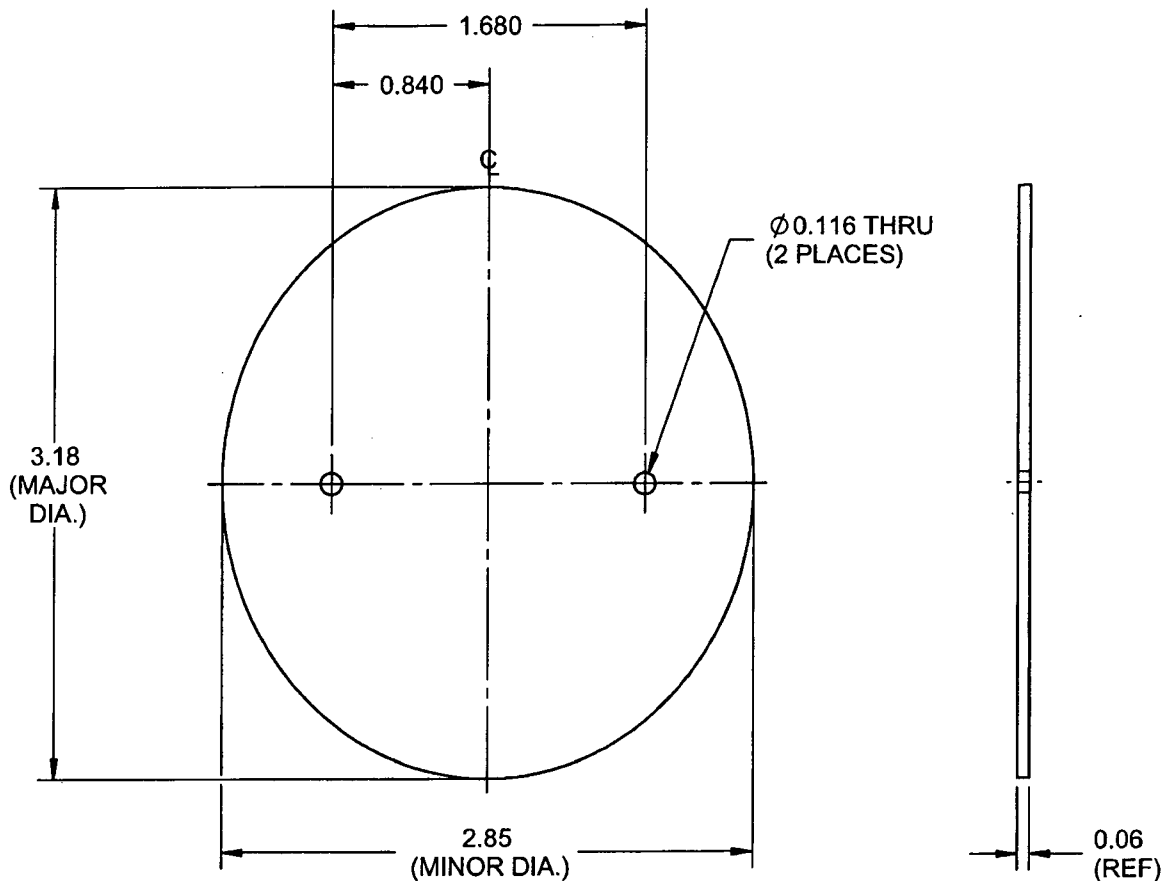
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DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:1

**D3470-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED  
06-04-03 *#*

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